

Date: Friday, 17/10/2008 12:44:23 PM
User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: N1 GEARBOX ACCESS PANEL KIT
Job Number	: 42727		
Estimate Number	: 12505		
P.O. Number	:	Part Number	: D412705017
This Issue	: 17/10/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3255 REV B
First Issue	: 1/1	Project Number	: N/A
Previous Run	: 42460	Drawing Revision	: B
	Type : SMALL /MED FAB	Material	:
Written By	:	Due Date	: 10/11/2008
Checked & Approved By	: <u>JLD 08.10.17</u>	Qty:	4 Um: Each
Comment	: Est Rev:C Removed Manufacturing 06-08-02 JLM : Est Rev:D ECN 1052 07-11-06 DD verified by: EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.11.10



Comment: Photocopy bluefile & type labels per PPPD412-705-017 CHG001

08.12.15

2.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0	D3255041	Access Panel Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Access Panel Assembly

Batch: 42469

B3 7404 2x

P-8/12/10 (2)

4.0	D3255042	Access Panel Assembly
-----	----------	-----------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Access Panel Assembly

Batch: 42761

SP

5.0	AN3C3A	Bolt
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Comment: Qty.: 30.0000 Each(s)/Unit Total: 120.0000 Each(s)

Bolt

Batch: M109311

M110139

A1012

4X

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/10/2008 12:44:23 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 42727

Part Number: D412705017

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20427M33

Rivet



Comment: Qty.: 36.0000 Each(s)/Unit Total : 144.0000 Each(s)

Rivet

Batch: M110022

7.0

MS21060L3K

Nut Plate



Comment: Qty.: 18.0000 Each(s)/Unit Total : 72.0000 Each(s)

Nut Plate

Batch: M1097210

8.0

MS932109

Washer



Comment: Qty.: 30.0000 Each(s)/Unit Total : 120.0000 Each(s)

Washer

M109740

8/12/12

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/12/15 (4x)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-705-017

Location: 31

PPP Rev: A

8/12/15

54

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/15

Job Completion



u 08/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

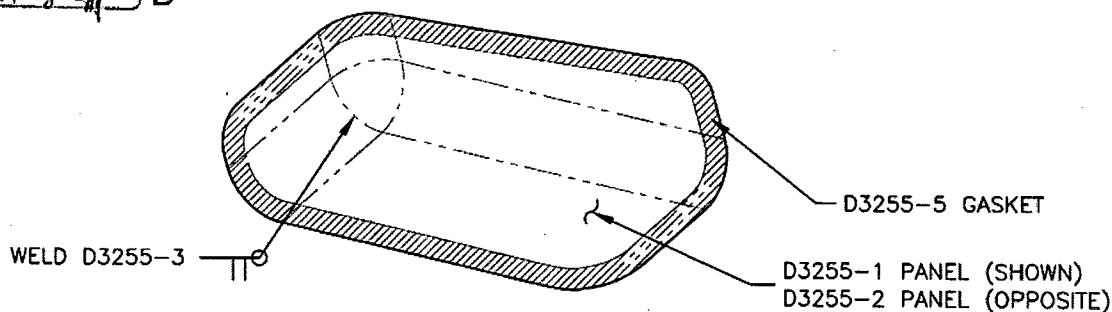
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

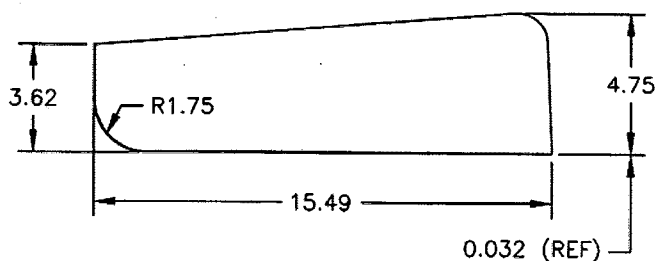
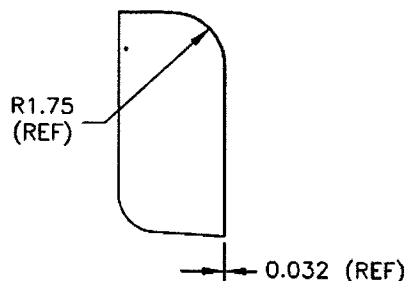
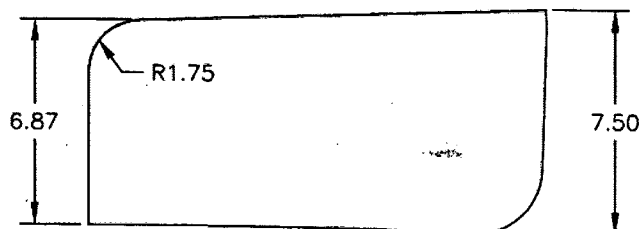


DESIGN TJ	DRAWN BY TJ	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05.01.18



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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WORK ORDER
NO. 42727

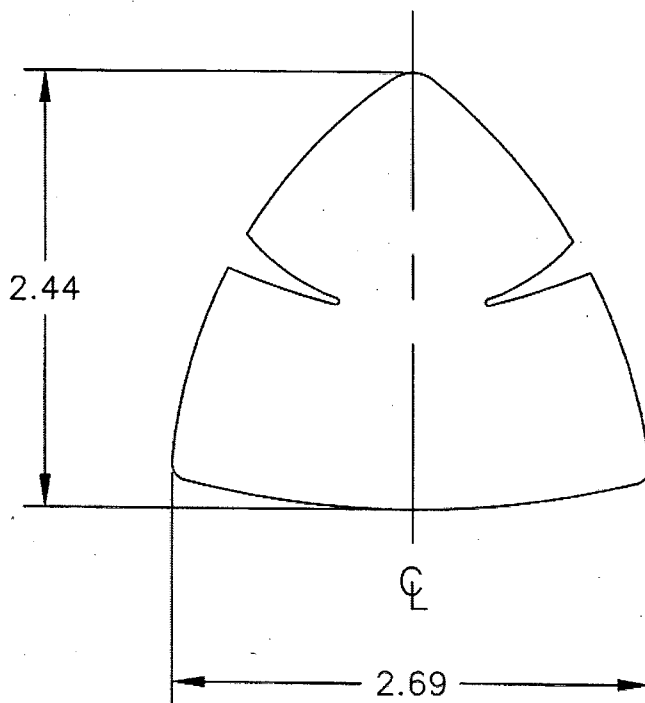
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CHECKED CP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05-01-18 JF



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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NO. 42727

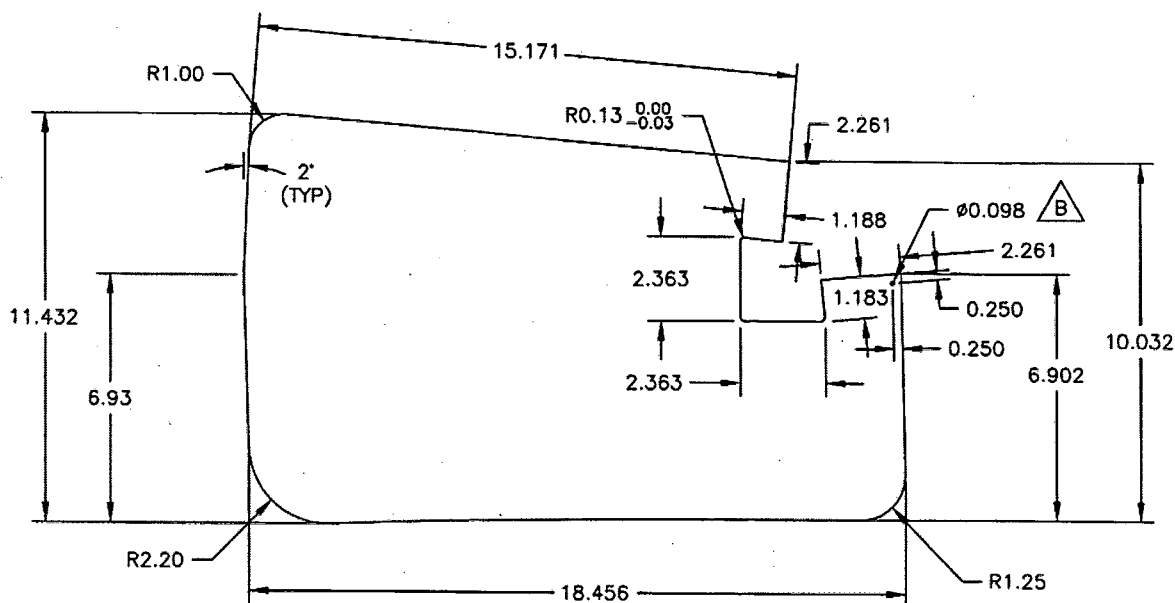
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CHECKED JP	APPROVED JH	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 42727

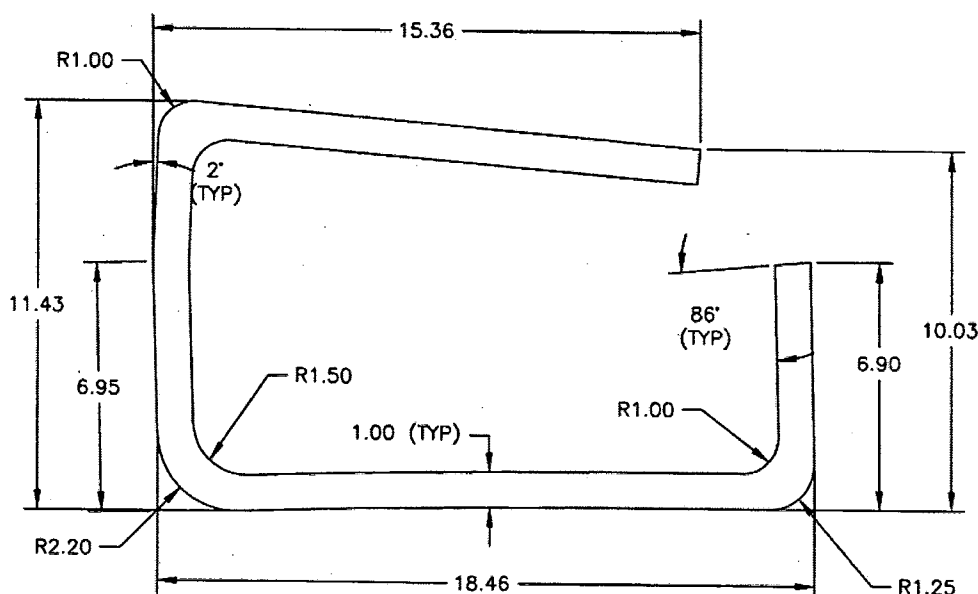
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CHECKED CP	APPROVED JT	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18 JT



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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